

Date: Friday, 9/21/2007 1:01:27 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34795
Estimate Number : 10449
P.O. Number : *N/A*
This Issue : 9/21/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 30953

Drawing Name : WHEEL SHAFT
Part Number : D33341
Drawing Number : D3334 REV. B1
Project Number : N/A
Drawing Revision : B1
Material : *N/A*
Due Date : 10/8/2007

Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est: B 05.03.02 Revised material; Added Powder Coat K
J/JLM

Qty: *2* Um: *10* Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4140HR3500 4140 Heat Treated Bar



Comment: Qty.: 0.6563 f(s)/Unit Total : 6.5630 f(s)
4140 HEAT TREATED BAR

Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400
(M4140H-R3.500) Batch: *M105801* *J.L. 07/10/15*

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI

1- Cut blanks: Ø3.500" Bar to 7.750" long - *J.L. 07/10/15*
2- Turn as per Folio FA492 and Dwg D3334
3- Deburr *[Signature] 07/10/18* (2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *[Signature] 07/10/18* (2)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS1

Machine as per Folio FA492 and Dwg D3334
Identify as D3334-1 *[Signature] 07-10-24* (2)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *[Signature] 07-10-24* (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL SHAFT

Job Number: 34795

Part Number: D33341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/25 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Mask thread and bearing surface

M18052

JD 07-10-26 (x2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JA-10-26 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: NS23

PC 07-10-29

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/10/29 (2)

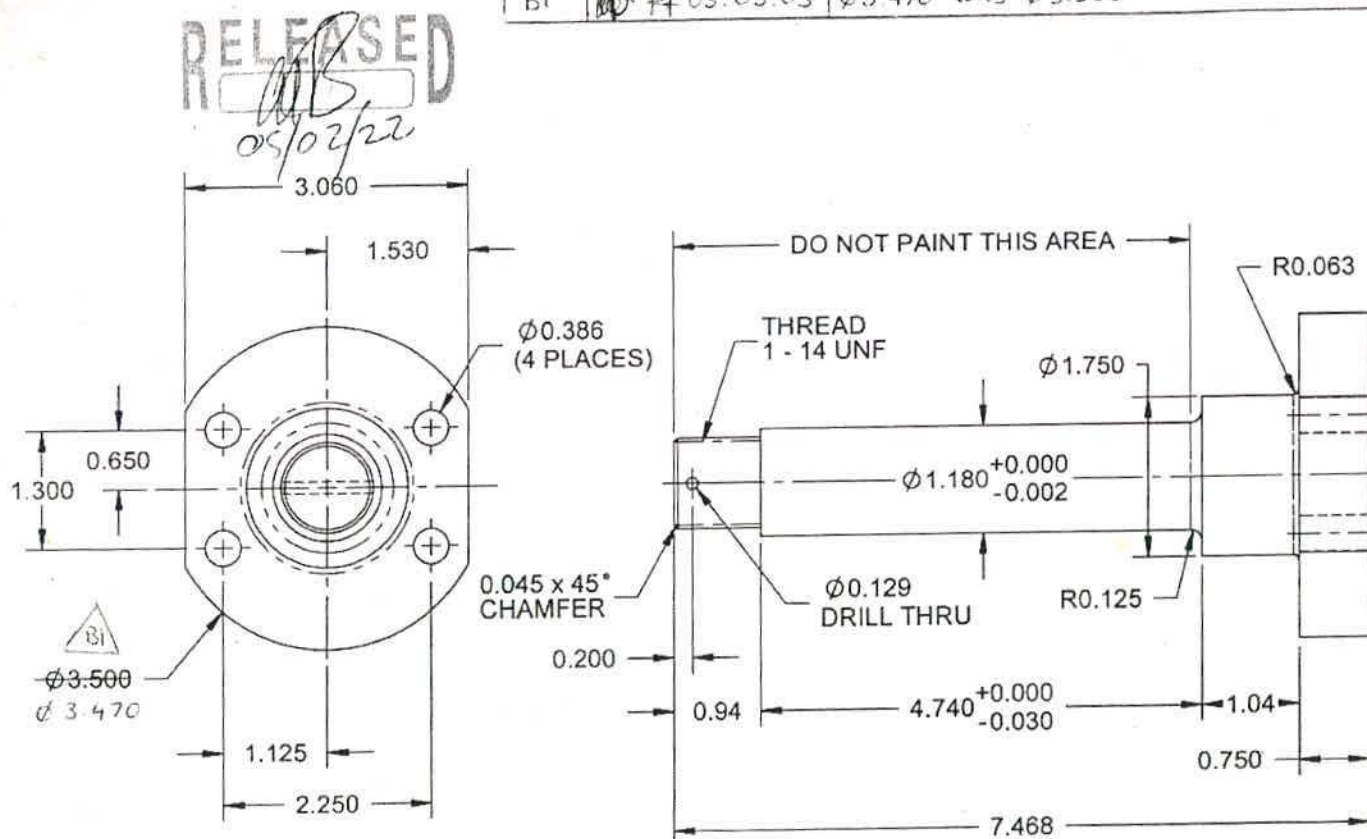
Job Completion



W 07.10.29

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	
BI	05.03.03	Ø 3.470 WAS Ø 3.500	

**D3334-1 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **34795**

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